



Dart Hawkesbury
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Tel (613) 632-5200

D4016-3
Job Sheet 168354



Part No: D4016-3

Job Qty: 10 ea

Part Name: Hinge Half, Lid



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/13/17

Job Tracking No:

Due Date: 11/24/17

Created By: Mario Poulin

Type: SOLD

Description:

Ship Via:

DWG Rev. B ✓

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup	Run	Workcenter / Supplier	Lead Time	
					hrs	Hrs			
90	Start up Operation	10 Ea	11/23/17	11/23/17	0.00	0.00	Start Up Machining		mmk 17/12/08
100	Bandsaw	10 pcs	11/23/17	11/23/17	0.00	0.39	Bandsaw1		" 17/12/08
110	CNC Vertical Machining	10 pcs	11/24/17	11/24/17	0.09	3.68	HAAS 1		FM 17/12/08
130	QC	10 pcs	11/24/17	11/24/17	0.00	0.00	QC8		17/12/10
160	Packaging	10 pcs	11/24/17	11/24/17	0.00	0.00	Packaging3	WA004	SLK 17/12/11
170	QC21-SA	10 Ea	11/24/17	11/24/17	0.00	0.00	QC21		17/12/11

Part Op 100 - CUT BLANK as per folio

Descriptions: 110 - MACHINE AS PER FOLIO FA874 AND DWG

160 - LOCATION: WA004

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M304B1.000X1.000	1	29	0	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Hinge Half, Lid	0.880Inches ± 0.030	0.910 0.850		
2	Hinge Half, Lid	0.130Inches ± 0.030	0.160 0.100		
3	Hinge Half, Lid	0.250Inches ± 0.010	0.260 0.240		
4	Hinge Half, Lid	0.030Inches ± 0.030	0.060 0.000	Radius	
5	Hinge Half, Lid	0.130Inches ± 0.030	0.160 0.100		
6	Hinge Half, Lid	0.500Inches ± 0.030	0.530 0.470		
7	Hinge Half, Lid	0.630Inches ± 0.030	0.660 0.600		
8	Hinge Half, Lid	0.563Inches ± 0.010	0.573 0.553		
9	Hinge Half, Lid	0.257Inches + 0.006 - 0.001	0.263 0.256	Diameter	

5016594

Plex 11/13/17 2:19 PM dart.poulin.mario

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS					
	Rework ☐	Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐			
	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐			
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐			
	Suspected Unapproved ☐	Large Fab ☐	Composite ☐	Supplier ☐				

Date : _____	Step #: _____	QTY Effective : _____	MRB (QSI042) Approval
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Description Work Order Deviation

DART
AEROSPACE
S016597



Hinge Half, Lid

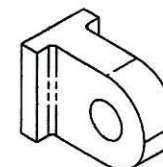
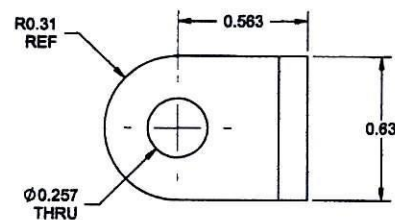
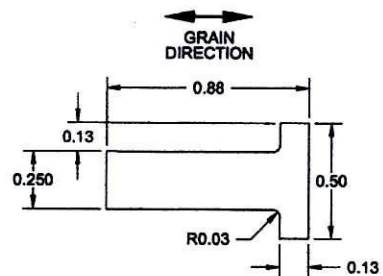
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Completed By

Lead hand / Supervisor
Approval VerificationQC / QA Coordinator
Approval**PART NO: D4016-3****Revision:
Operation:
Change No:****Start up Operation****Mfg Date: 12/03/17****Job No: 168354**

Root Cause									
Environment ☐	No Re- ☐	Crushing ☐	Countersink ☐	Off-set ☐	Positioned Wrong ☐	Surge ☐	Outside Dimensions ☐	Over/Under tolerance ☐	Part Incorrect ☐
Design ☐	Operat ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Part Lost/Missing ☐	ogram ☐	Part Moved ☐	Drawing ☐	Finish ☐
Doc/Data ☐	Offset/ ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Part Moved ☐		Part Moved ☐	Turning Sequence ☐	
Equip/Tooling ☐	Supplie ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐					
Handling/Pre ☐	Training ☐								
Material ☐	Use for ☐								
Internal Transport ☐	Poor Inf. ☐								
Tribal Knowledge ☐	Rushing ☐								
LOA ☐	Product Improvement ☐								
Substation ☐	Process Improvement ☐								
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐								
OTHER : _____									



D4016-3 HINGE HALF, LID

D4016-5 HINGE HALF, LIGHT LID

NOTES:

1) MATERIAL -3: 304/316 STAINLESS STEEL BAR, PER ASTM A276
REF DART SPEC M304B

-5: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR,
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT -3: 0.04 lbs

-5: 0.01 lbs

RELEASED
2017-03-22

APPROVED

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	RF			
CHECKED	WK		DRAWING NO.	REV. B
MFG. APPR.	JLM		D4016	SHEET 2 OF 3
APPROVED	HS		TITLE	SCALE
DE APPR.	DS		BASKET HINGE	NTS
DATE	17.02.09	COPYRIGHT © 2010 BY DART AEROSPACE LTD		
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